

Work Order ID 53458

November 6, 2009 8:21:19 AM



Page 1

Item ID:	D3175-041	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Mounting Lug					
Start Date:	05/11/2009	Start Qty:	12.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09/11/15	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3175	Rev A								

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

(2) blanks required per (1) D3175-041 assembly ☐ Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2")

SL 09/11/16

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA293 and Dwg D3175 ☐ Deburr and Tumble ☐ Identify as D3175-1

SL / mwp
09/11/17

12 x 2 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL / mwp
09/11/17

12 x 2 0

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Item ID: D3175-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Mounting Lug

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

mf 09/11/17

12 10

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

=> M 09/11/18

24

8

Hand Finishing

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BK 09-11-18

24

Quality Control

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Start Date:	05/11/2009	Start Qty:	12.00		Cust Item ID:	
Required Date:	13/11/2009	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3175								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	M112140	0.00							
Powder Coating	Memo								
	START TIME: 11:00am								
	FINISH TIME: 11:30am								
	OVEN TEMPERATURE: 320°								

Ep 09/11/18 (12)

2 Sorbules *Assemblies* (12) *f*

Jel 09/11/18 (12) *0*

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Item ID: D3175-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Mounting Lug

Start Date: 05/11/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: <u>72</u>	0.00							
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

WMO 09/11/18

X12

PC 9/11/20 12

09/11/24 J
PL 09-11-20
(12)

Picklist Print

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Work Order ID: 53458

Parent Item: D3175-041RevA

Parent Item Name: Mounting Lug



Comments:

Start Date: 05/11/2009



Required Date: 13/11/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			100	Each	3,196.000	24.0000			
												
Nut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3196	
110844	32	
111274	27	
111668	645	
112314	1992	
112385	500	

AN3-7A		Purchased	No			160	Each	57.0000	24.0000			
												
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	57	
110704	2	
111127	55	

09/11/18

24

09/11/18

24

Picklist Print

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Parent Item Name: Mounting Lug



Comments:

Start Date: 05/11/2009

Required Date: 13/11/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L  Washer		Purchased	No			160	Each	5,721.000	48.0000		 09/11/18	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5721

101291

16

104885

153

105793

236

109632

412

110985

4904

48

D3175-3RevA

Manufactured

No

160

Each

15.0000

12.0000



Spacer



09/11/18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

25027

15

12

Picklist Print

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Parent Item: D3175-041RevA



Parent Item Name: Mounting Lug

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			160	f	104.5115	2.4202			



6061-T6 Bar 1.50 x 2.50

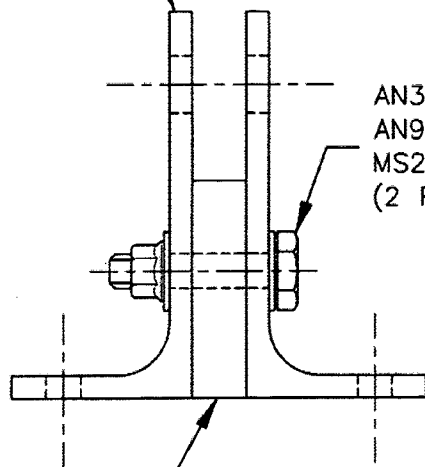
<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	104.5115	
103069	12	
107387	70	
16716	20.7115	
16742	1.8	

2.4202

and 09/11/17

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

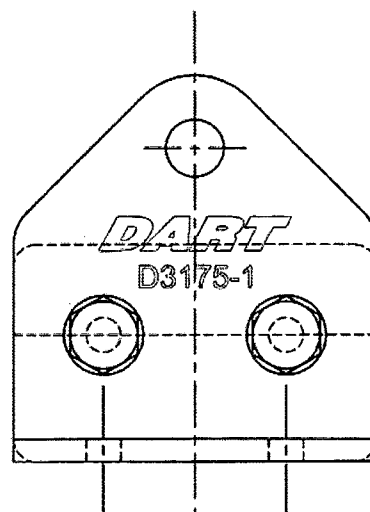
D3175-1
(2 PLACES)

AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)

D3175-3

D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

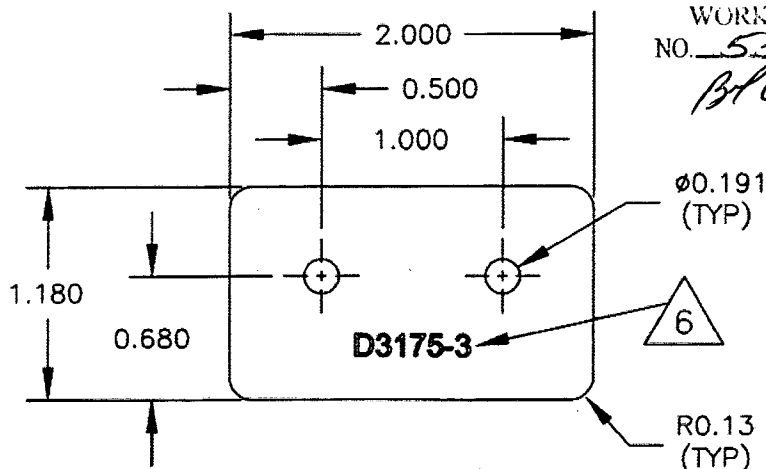


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WITHOUT NOTICE
WORK ORDER

NO. 53458*B109-11-5*RELEASED
02.12.03 *#***D3175-3 SPACER**

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

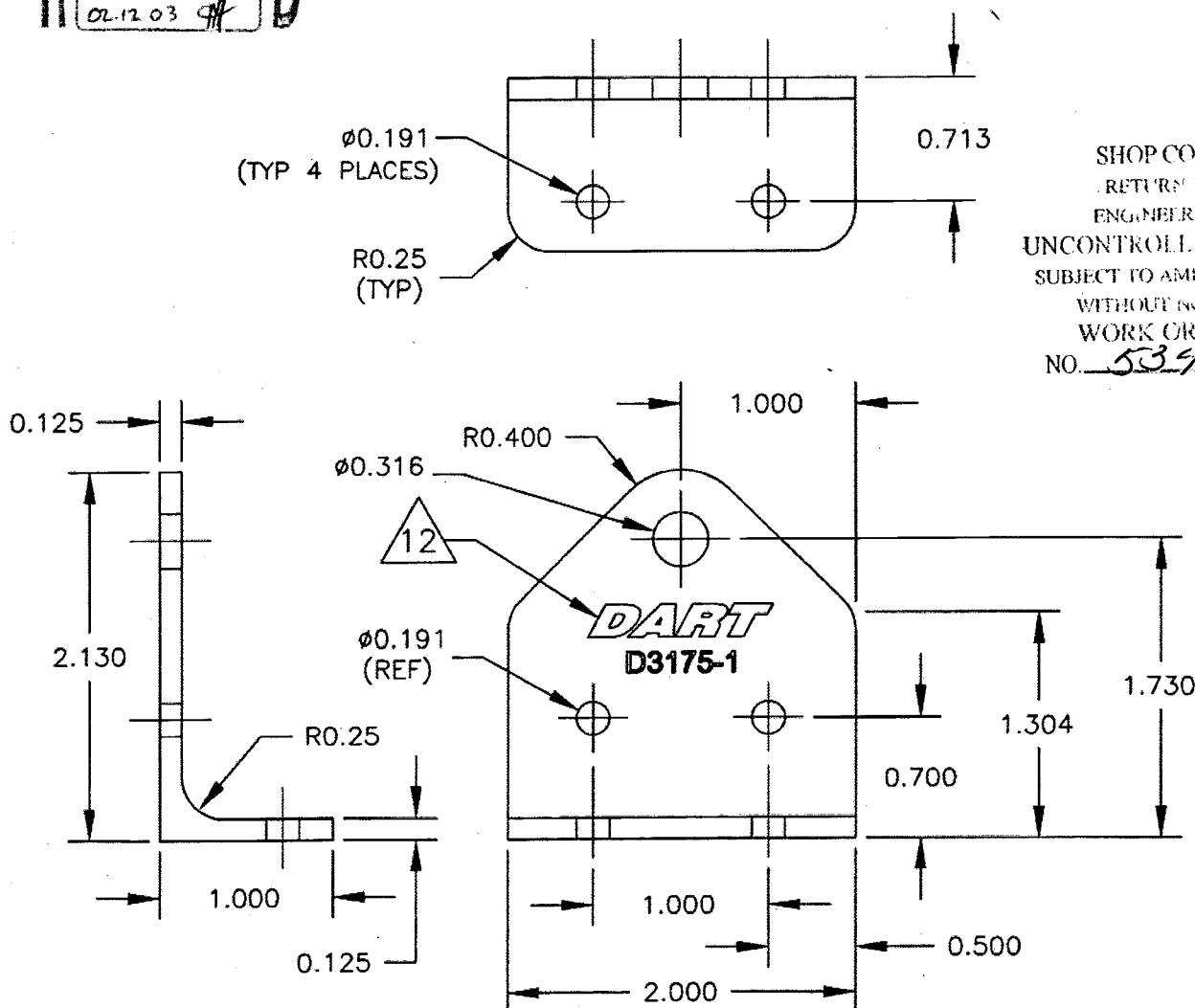
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
02.12.03



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WORK ORDER
NO. 53458

D3175-1 BRACKET

7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)

8) BREAK ALL SHARP EDGES 0.005 TO 0.015

9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11) ALL DIMENSIONS ARE IN INCHES

12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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